

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54948

January 5, 2010 10:17:59 AM



Page 2

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Item Name: SPACEPOD DOOR RH

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: CAUQ05121 0.00



Packaging

Memo

0.00

Packaging

BT 10-0505

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06 *[Signature]*

C2101514

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:18:03 AM

Page 1

Work Order ID: 54948



Parent Item: D3186-2M



Parent Item Name: SPACEPOD DOOR RH



Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2P  Spacepod Door		Purchased	No			100	Each	0.0000	1.0000			
B54948											RT 10-05-05	

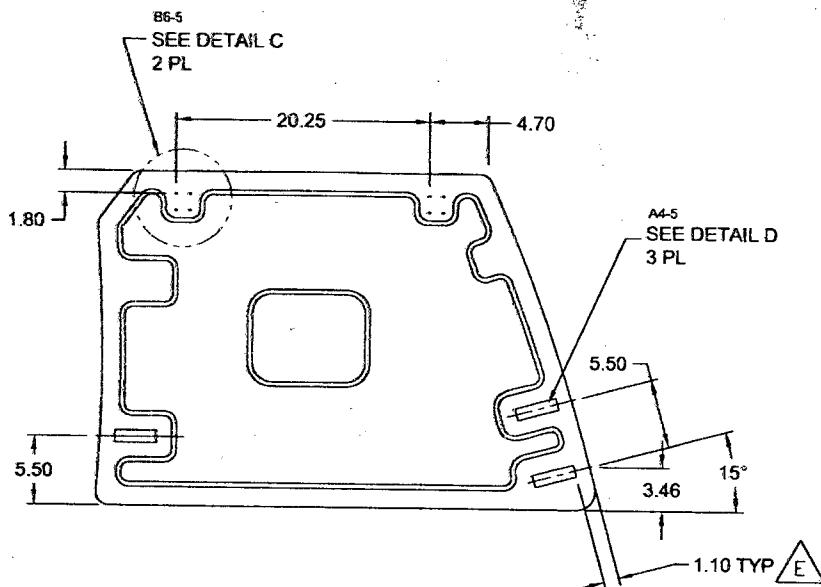
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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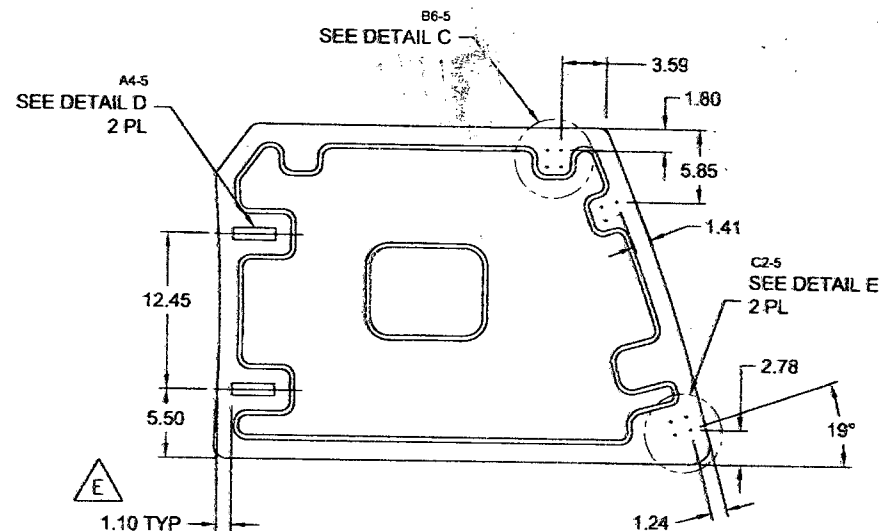
NOTE: Date & initial all entries



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54948

RD10-1-05

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED 00600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	<small> COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

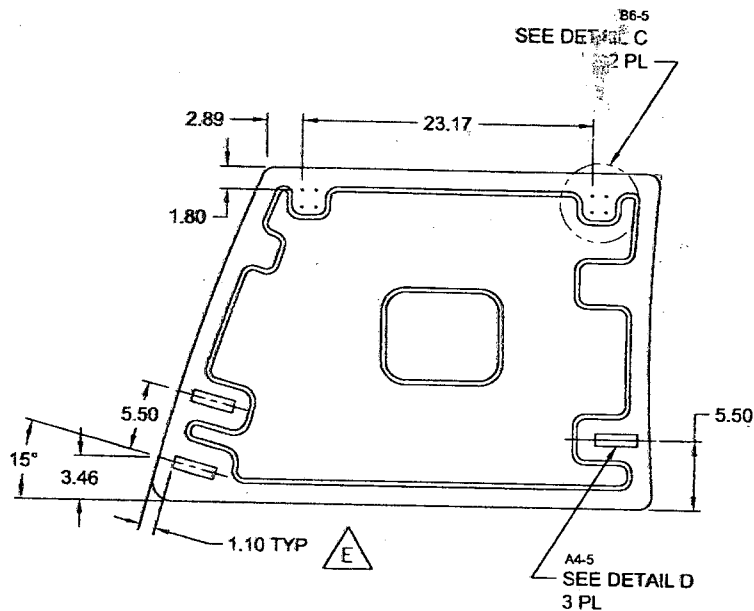
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

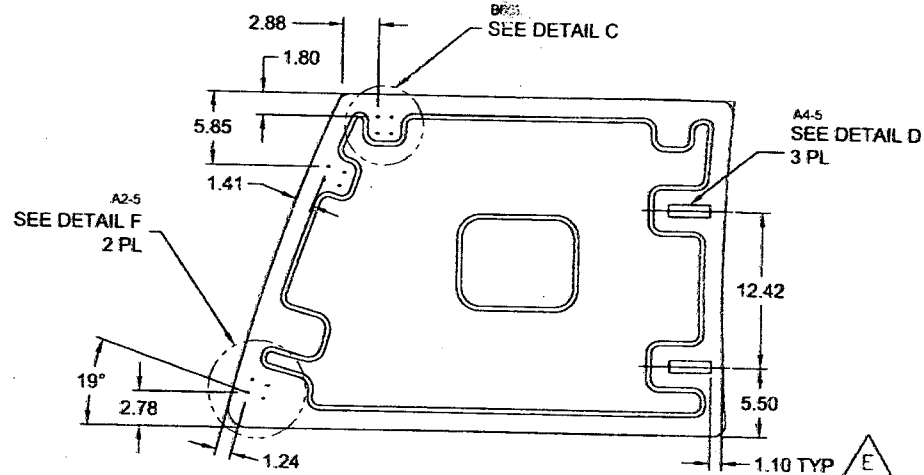
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2009-03-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	GR	DRAWING NO.	REV. E
MFG. APPR.	MD	D3186	SHEET 2 OF 5
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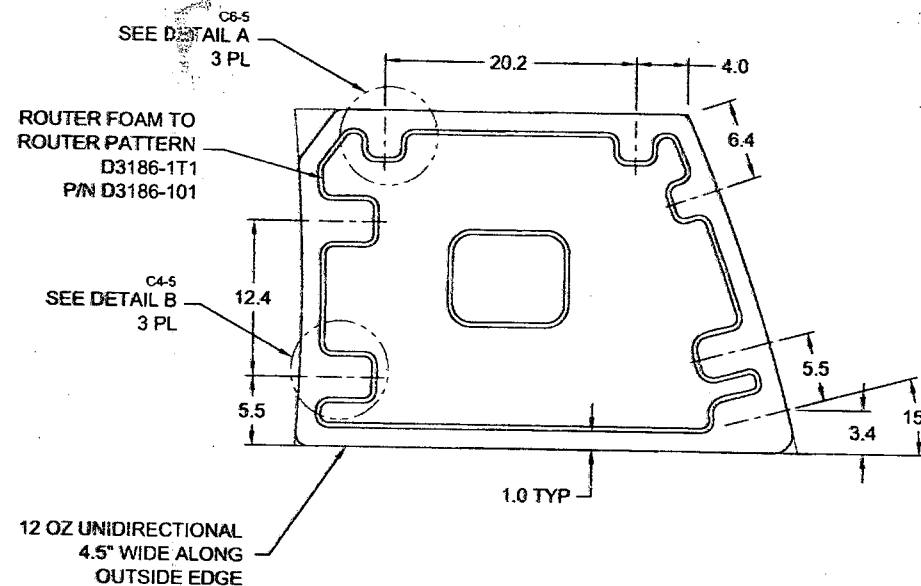
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-1M SPACEPOD DOOR AS MOLDED

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

RELEASED
2008-08-08

W/0 54945

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D3186	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SPACEPOD DOOR	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

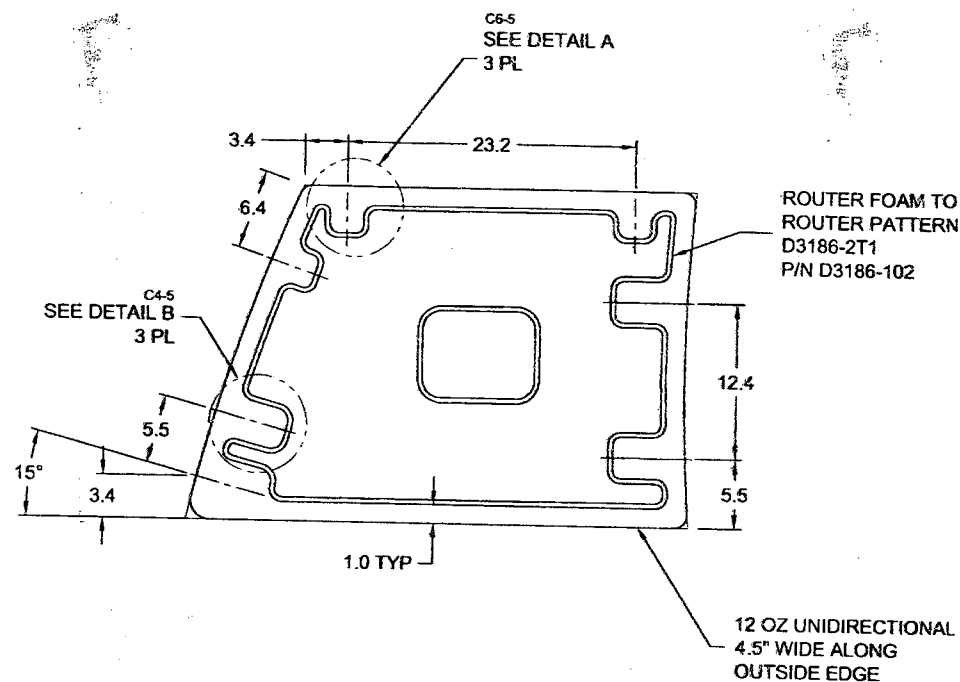
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2009-08-09

W/0 54948

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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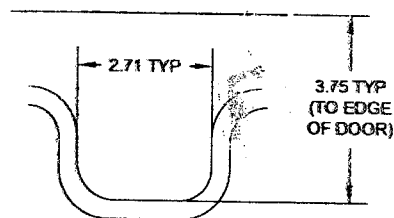
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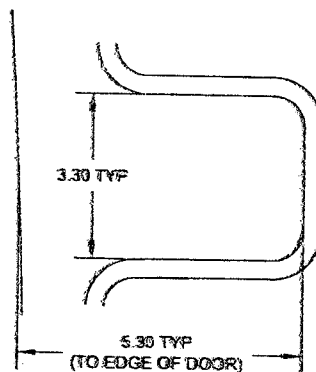
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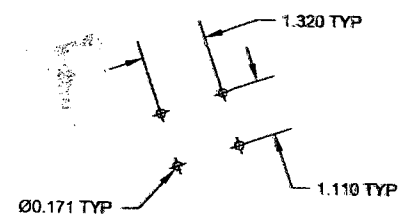
NOTE: Date & initial all entries



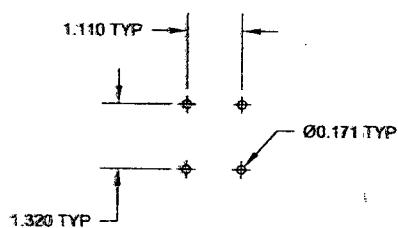
DETAIL A D6-3
SCALE 4X D4-4



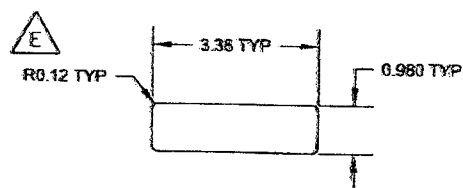
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

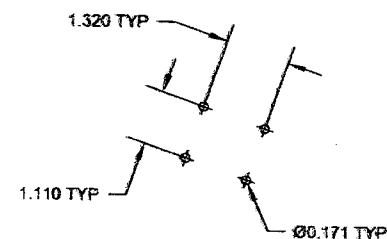


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2008-07-10

W10 54948

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	32478
Customer #	DART US

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #	
15/04/2010	06/01/2010	13673	Chantal Lavoie	PO11041			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0060	Line #3 D31862P Spacepod Door RH B54948 Dwg. Rév.: E			
				No. lot 24690			
				Qté 1			
1	0	1	DKC134-0071	Line #4 D31882P, Spacepod Body RH B54944 Dwg. D3188 Rév.: F			
				No. lot 24023			
				Qté 1			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mardi, 2010-03-02 14:04:34
Utilisateur: Louis Jodoin

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD DOOR RH
Numéro Job	: 24690	Numéro Article	: DKC134-0060
Numéro Soumission	: 3769	Numéro Dessin	: D3186
Numéro B.A.	:	Projet Numéro	: DK-359
Cette fois	: 2010-03-02 No. B.V. :	Révision dessin	: E
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: - - Type :	Date Dûe	: 2010-03-09 Qté: 1 Udm: UNITE
Job précédente	: 24689		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D31862M		

Process Sheet Rév.: 00 création du premier à partir du
DKC134-0058 dans Delastek Aéronautique

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0085	FREKOTE 3,78L 44-NC

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009

Date: / Sceau: /

3.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)

4.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)

5.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

6.0	AC0943	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-26083-1

8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
-----	--------	-----------------------------------

Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)

Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24690

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

9.0

AMB0349

Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE(s)/Unit Total: 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

10.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 03 mars 10 Sceau:



11.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0080 GALLON(s)/Unit Total: 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

12.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 LITRE(s)/Unit Total: 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26643-1

13.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 10-3-10 Sceau:



14.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 10-3-10 Sceau:



Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24690

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

15.0

BAGGING

Faire le bagging sur la pièce



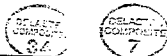
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 1:55 Heure Fin Curing: 8:00

Date: 10-3-10 Sceau:



16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total: 0.0120 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total: 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-26643-1

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core

Date: 3-3-10 Sceau:



19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2) # de Job: 44039

20.0

AAC1611

Polybond B46F

Commentair Qty.: 0.090 KIT(s)/Unit Total: 0.090 KIT(s)

Polybond B46F N° de Lot: 1-25391-1

21.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Date: Mardi, 2010-03-02 11:00:00

Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24690

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 11-3-10 Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 2 heures minimum

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 10:35

Heure Fin Curing: 8:00

Date: 11-3-10 sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-26643-1

25.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 12-3-10 Sceau:



26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 12-3-10 Sceau:



Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24690

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 8:30

Heure Fin Curing: 1:45

Date: 12-3-10 sceau:



28.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges selon IG 0018.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 12-3-10 Sceau:



29.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 12-3-10 Sceau:



30.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-26006-1

31.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-26575-5

32.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008

Date: 22-03-10 Sceau:

29/03/10



Date: 17/04/2010 14:07:07

Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24690

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: _____ Sceau: _____

Date: _____ Sceau: _____

Date: _____ Sceau: _____

33.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.020 KIT(s)/Unit Total : 0.020 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

de Lot: 1-7191-1

34.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

de Lot: _____

35.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du sikkens.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Heure début Curing: _____

Heure Fin Curing: _____

Date: 30/04/10 Sceau: _____



36.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

de Lot: 1-26006-1

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

de Lot: 1-26575-5

38.0

PRIMER

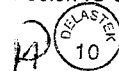
Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer une couche de primer selon IG 0008

Date: 06/04/10 Sceau: _____



Date: 09/04/10 Sceau: _____



Date: _____ Sceau: _____

Date: _____ Sceau: _____

Date: Mardi, 2010 03 02 11:05:10

Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24690

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

39.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 12-4-10 Sceau:



40.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 13-04-10 Sceau:

